

Work Order ID 100650

April-25-13 1:28:48 PM

100650

Page 1

Item ID: D4020-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: End Mesh. Basket

Start Date: 4/25/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/09/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

MLJ

Date: 130425

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4020

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4020

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

mesh S.S.

20

0

JMB-4-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET

20

0

JMB-4-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET

20

DAS
27
134
30

Work Order ID 100650

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Page 2

Item ID: D4020-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: End Mesh, Basket

Stop *NS2*

Start Date: 4/25/13 Start Qty: 20.00

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Cust Item ID:

Required Date: 5/09/13 Req'd Qty: 20.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(20)

13-04-30

13/5/6

13-05-1

Picklist Print

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Work Order ID: 100650

100650

Parent Item: D4020-11

D4020-11

Parent Item Name: End Mesh, Basket

Start Date: 4/25/13

Required Date: 5/09/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP RevA: new issue DD 09.11.26 verified by:EC
per dwg revA 10.03.15 verified by:EC
cut out from dxf, will be made when install on basket DD verf:JLM

IPP Rev:B as

IPP Rev:C 10.06.14 remove

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304EX0.75-16F

Purchased

No

100

sf

349.2391

2.694

56.71579

M304FX0 75-16F

Expanded Metal Flat SS

**

60

Jm 13-4-29

Location

Loc Qty

Loc Code

MAT

269.2791180

125113

269.279118

WA

64

124466

64

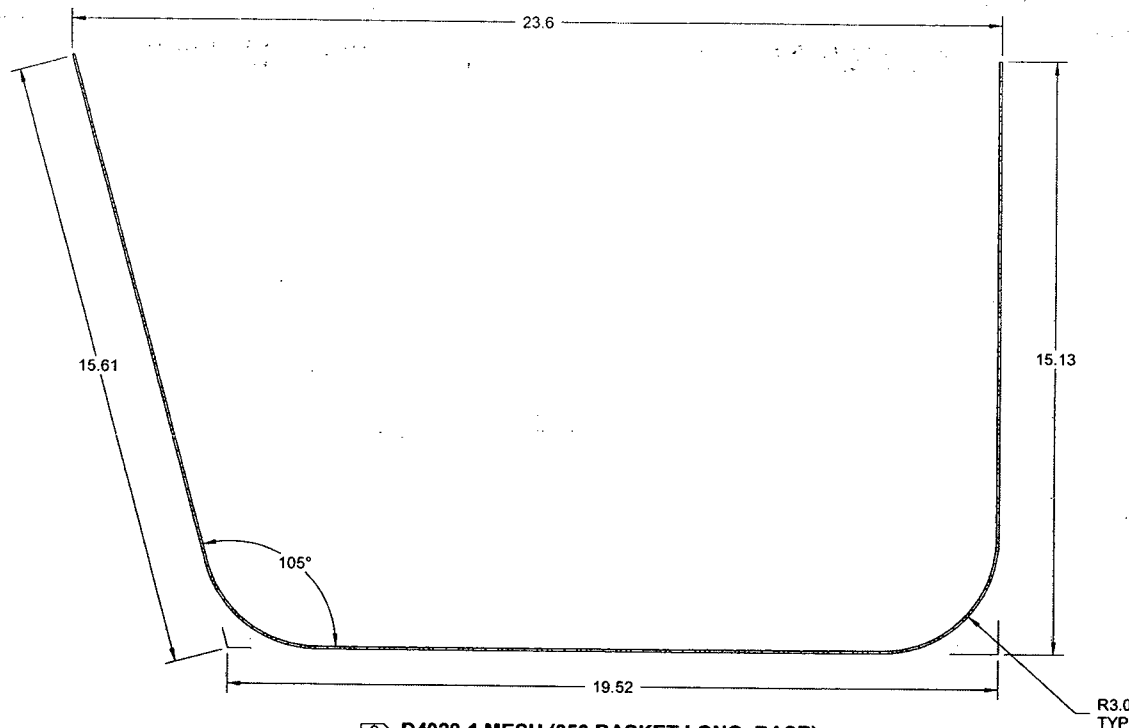
WA007

15.96

123448

15.96

125113



9 D4020-1 MESH (350 BASKET LONG, BASE)
(SEE D4020-1F FOR LENGTH)

9 D4020-3 (350 BASKET SHORT, BASE)
(SEE D4020-3F FOR LENGTH)

SHO
UNC
SUP
HOUT
OR
NO 100685 MLS
1304-25

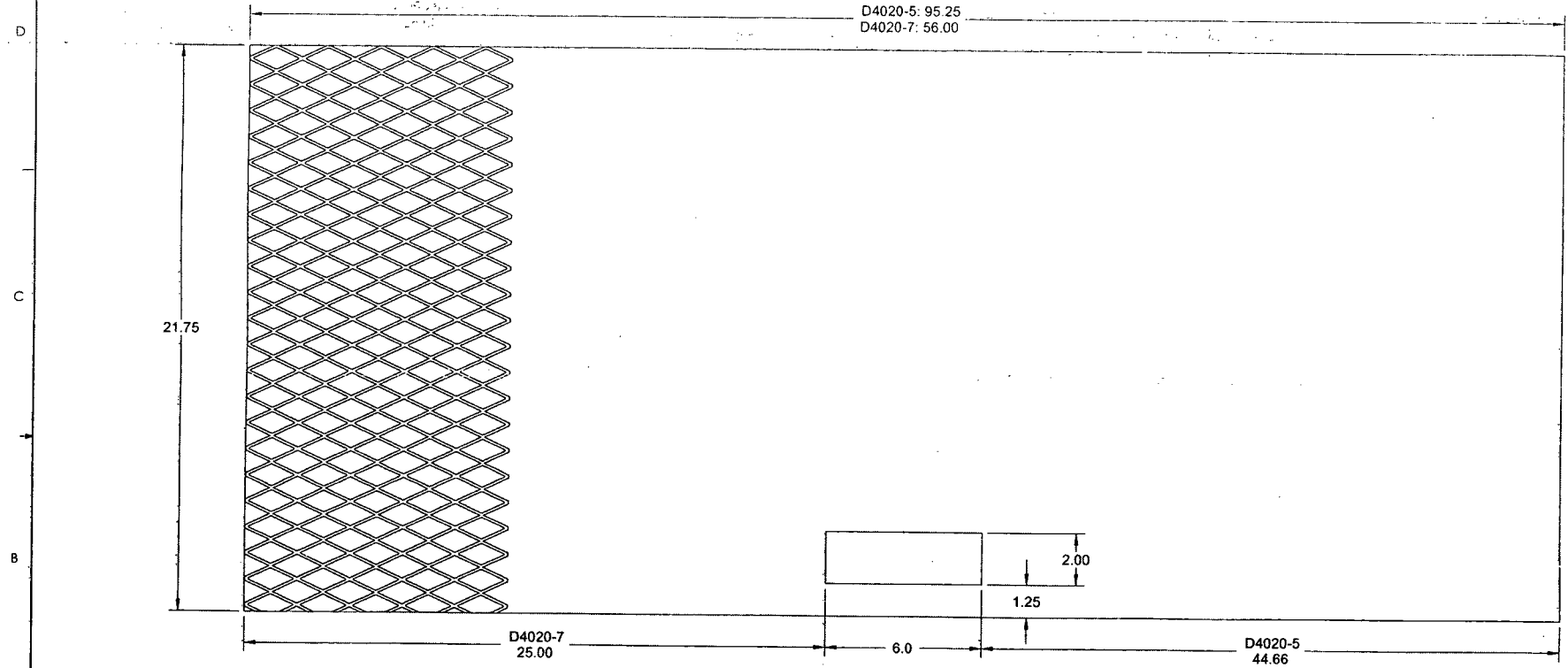
RELEASED
2010-03-12
WPH

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	W	DRAWING NO.	REV. A
MFG. APPR.	E	D4020	SHEET 1 OF 4
APPROVED	WPH	TITLE	SCALE
DE APPR.	WPH	350 BASKET MESH (BASE)	NTS
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100650



9 D4020-5 MESH (350 BASKET LONG, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

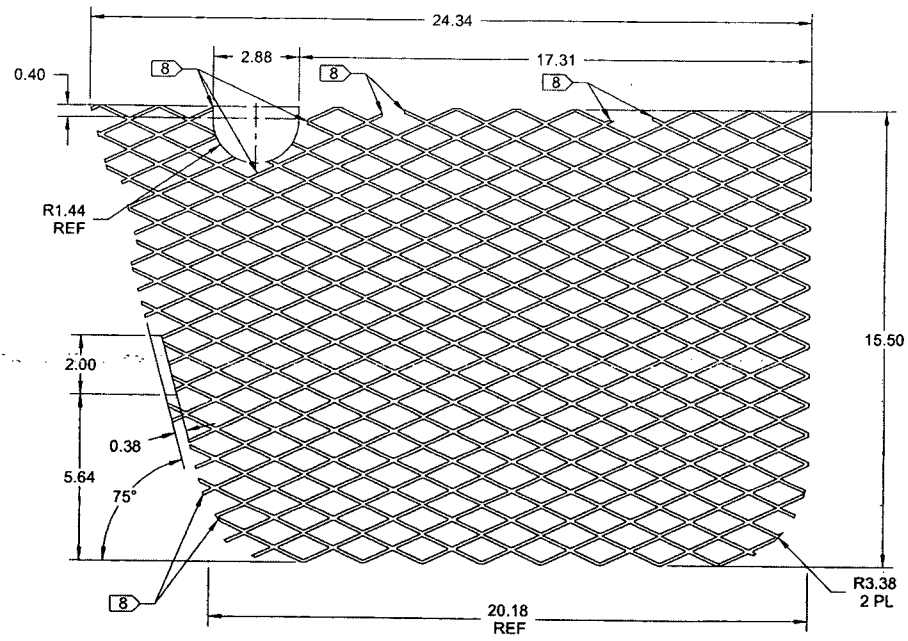
RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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9 D4020-11 END MESH, BASKET

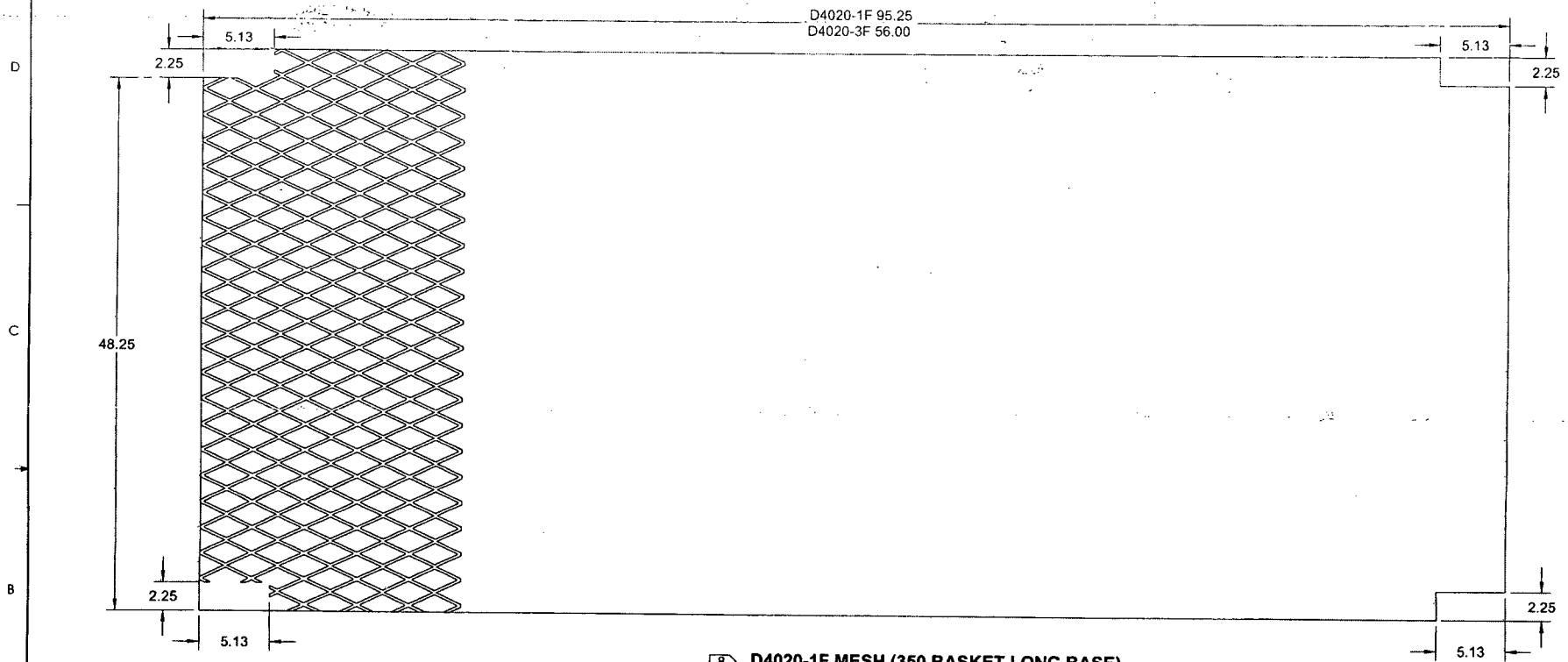
RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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MFG. APPR.	<i>[Signature]</i>	TITLE 350 BASKET MESH (BASE)	SCALE NTS
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DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		

100650



- 8 D4020-1F MESH (350 BASKET LONG BASE)
(LOCAL SECTION MESH SHOWN FOR CLARITY)
- 8 D4020-3F MESH (350 BASKET SHORT, BASE)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-13
JW

- NOTES:
- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
 - 8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A SHEET 4 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE 350 BASKET MESH (BASE)	SCALE NTS
APPROVED	<i>[Signature]</i>	DATE 10.03.04	
DE APPR.	<i>[Signature]</i>		

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